

# Work Order ID 74808

**\*74808\***

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October 6, 2011 2:36:20 PM

Item ID: D4035-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Lid Rib Assembly, Aft (350 Basket)  
 Start Date: 10/06/11 Start Qty: 3.00 **\*3\*** Cust Item ID:  
 Required Date: 10/14/11 Req'd Qty: 3.00 **\*3\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.S Date: 11/10/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

**\*100\***

Large Fab

Large Fab

## Memo

0.00

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

11/10/07 (3x)

110 QC10- Inspect visual per QSI004- ground welds. 0.00

**\*110\***

QC

Quality Control

## Memo

0.00

11.10.31 3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

ml 11 10 31 (3)

Basket cell 11/11/09 (3x)

11/11/14

11-11-11 (3)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

October 6, 2011 2:36:24 PM

Page 1

Work Order ID: 74808

**\*74808\***

Parent Item: D4035-043

**\*D4035-043\***

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 10/06/11

Required Date: 10/14/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP revA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-9		Manufactured	No			100	Each	72.0000	2	6			
<b>*D4021-9*</b>													
Bushing													

\*\*

*LY 11/10/27*

Location	Loc Qty	Loc Code
WA	70	
70333	14	
72482	56	
WA005	2	
66437	2	

(6x)

M304TS0.750W.049 Purchased No

100 f 552.4164 1.75 5.526316

**\*M304TS0 750W 049\***

304 SQ Tube .75x.75x.049W

\*\*

*LY 11/10/27*

Location	Loc Qty	Loc Code
MAT018	483.4991839	
117775	93.6739	
118472	51.5848839	
118880	51.2404	
119147	287	
MAT034	1.8507	
117337	1.8507	
WA	67.06654	
118184	67.06654	

*5.52 + 1\* END BAR SCRAP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

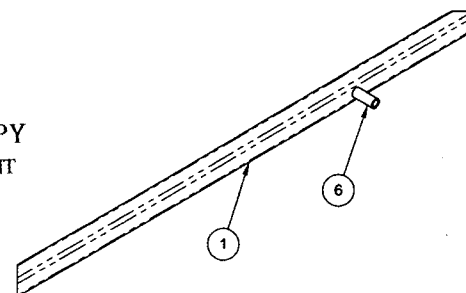
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

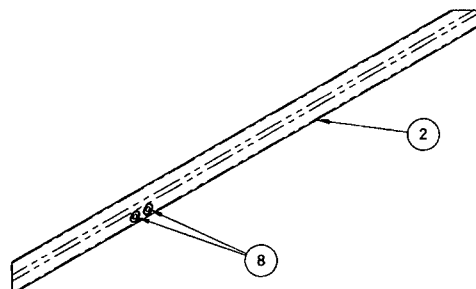
NO. 74808

M.L.J

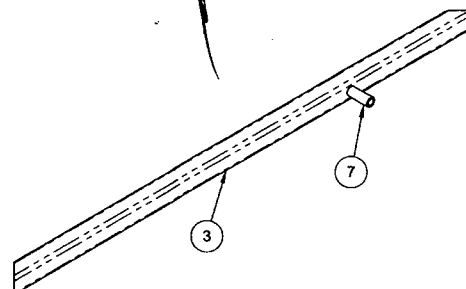
11/10/06



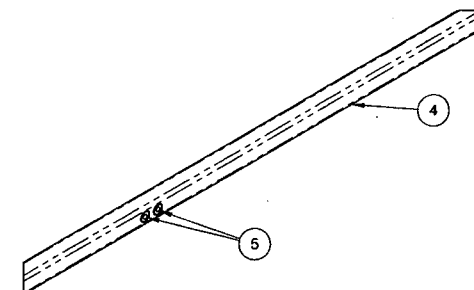
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-22

A	NEW ISSUE	DESCRIPTION	JPH	10.03.04
REV.			BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4035	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		BASKET LID RIB ASSY	NTS	
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

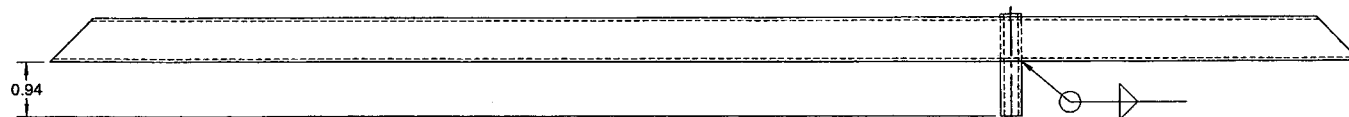
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74808

D4035-1  
RIBD2327-3  
SPACER BUSHING**D4035-041 BASKET LID RIB ASSY, FWD**D4035-3  
RIBD4021-9  
BUSHING  
2 PL

TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. <b>D4035</b>	REV. A
MFG. APPR.		TITLE <b>BASKET LID RIB ASSY</b>	SHEET 2 OF 5
APPROVED		SCALE NTS	
DE APPR.		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.03.04		

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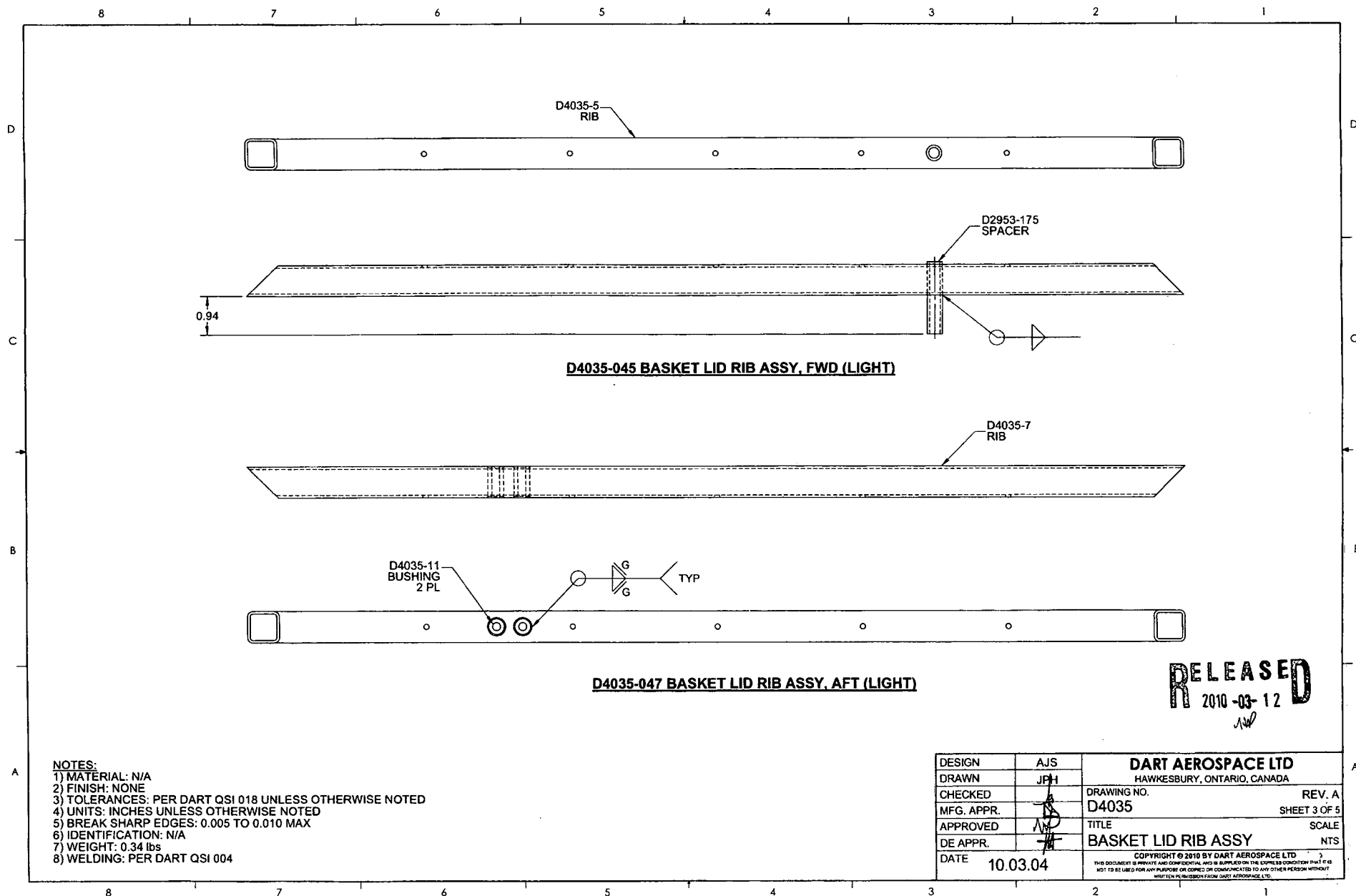
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2010-03-12

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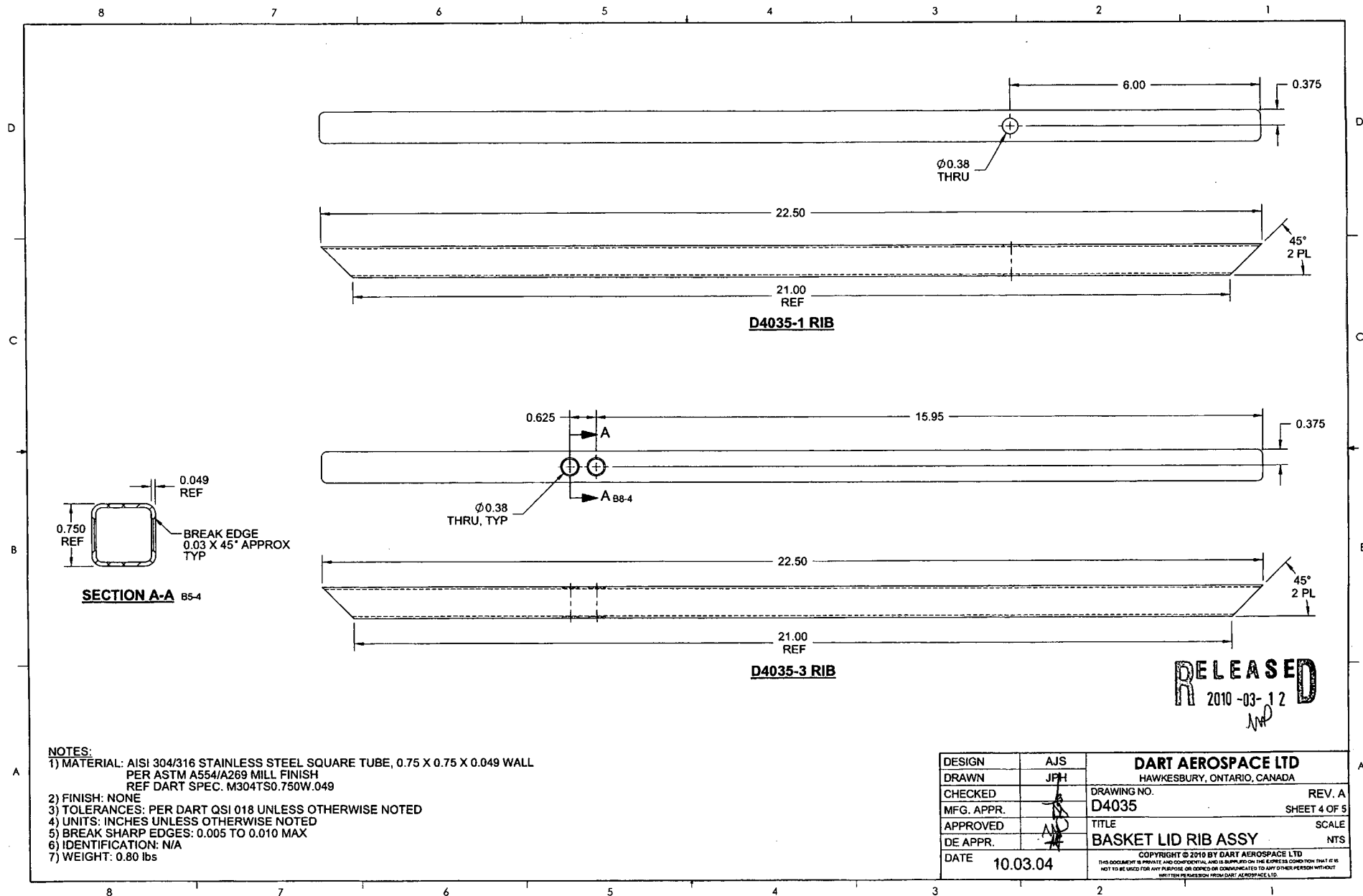
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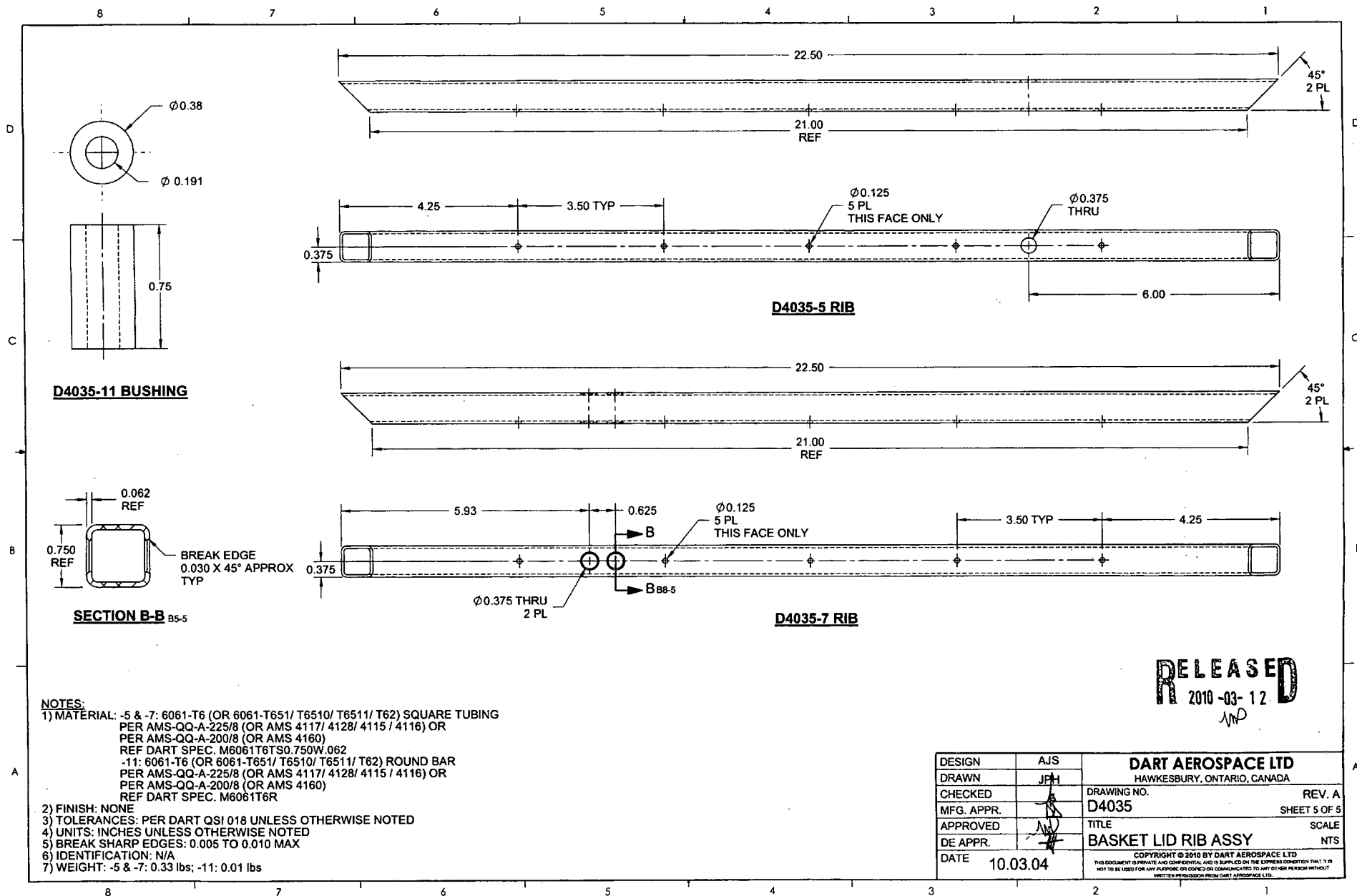
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